

19-7568



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5248

D5062-041

Job Sheet 196177



Part No: D5062-041

Job Qty: 8 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/7/19

Job Tracking No:

Due Date: 6/18/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A 14.02.11 NEW ISSUE DD VERF:JLM IPP REV:B 14.05.28 AS PER DWG REV.A DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs		6/18/19	0.17	0.49	Waterjet - Flow		JRB
110	QC 2	8 pcs		6/18/19	0.00	0.00	QC 2 - 1		T
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	8 pcs	6/18/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS JUN 17 2019 40
				QC 8 - 52	9-89
				QC 8 - 23	
				QC 8 - 57	
130 Small Fab - Brake NC - B4B	8 pcs	6/18/19	0.25 2.44	Small Fab - Brake - 1 - B4B	JUN 14 2019
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	8 pcs	6/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS JUN 14 2019 40
150 Handfinish - 1-1 Chemical-B4B	8 pcs	6/18/19	0.00 0.38	Handfinish - 1 - 1 - B4B	9-89
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	JUN 25 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	

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					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160 QC 7	8 pcs	6/18/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	SMB 19/6/25
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
170 Small Fab - 2 - B4B	8 pcs	6/18/19	0.00 0.77		Small Fab - 1 - B4B	SMB 19/6/25
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
180 QC 5	8 pcs	6/18/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	

					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	DAS JUN 25 2019 30 9-89
					QC 5 - 40	
190 Spray Paint - 2 - B4B	8 pcs	6/18/19	0.00 0.67		Spray Paint - 1 - B4B	AS 19-6-26
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
200 QC 14	8 pcs	6/18/19	0.00 0.00		QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	DAS JUN 27 2019 40 9-89
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
210 Packaging 3-1 - Stock - B4B	8 pcs	6/18/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	DAS 74 JUN 27 2019 9-89
					Packaging 3 - 5 - B4B	ST136
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	

220 QC 21 - SA	8 pcs	6/18/19	0.00 0.00	Packaging 3 - 35 - B4B	DAS 77 9-89
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB)
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Bend/Assemble as per dwg)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - (Small Fab)
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Spray Paint / NDT Room) 5189559
 200 - QC14- Inspect Spray Paint)
 210 - Packaging3-2 (Identify as per dwg & Stock Location: _____)
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	1.6000 sf (.2 ea)	100-Waterjet - Flow - 1	5167936x8
MS20470AD4-5	Rivet, Universal Head	32 Ea (4 ea)	170-Small Fab - 2 - B4B	5134218

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.080	2	38	0
170-Small Fab - 2 - B4B	MS20470AD4-5	32	1,289	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket Assembly	0.098Inches + 0.004 - 0.001	0.102 0.097	2.099	
2	Bracket Assembly	0.750Inches ± 0.010	0.760 0.740	0.754	
3	Bracket Assembly	0.030Inches ± 0.030	0.060 0.000	0.030	
4	Bracket Assembly	1.000Inches ± 0.010	1.010 0.990	1.006	
5	Bracket Assembly	1.750Inches ± 0.030	1.780 1.720	1.750	
6	Bracket Assembly	3.940Inches ± 0.030	3.970 3.910	3.939	
7	Bracket Assembly	4.330Inches ± 0.030	4.360 4.300	4.330	
8	Bracket Assembly	5.080Inches ± 0.030	5.110 5.050	5.080	
9	Bracket Assembly	9.460Inches ± 0.030	9.490 9.430	9.460	
10	Bracket Assembly	1.160Inches ± 0.030	1.190 1.130	1.160	
11	Bracket Assembly	1.360Inches ± 0.030	1.390 1.330	1.362	
12	Bracket Assembly	4.0400Inches ± 0.0300	4.0700 4.0100	4.0400	
13	Bracket Assembly	2.950Inches ± 0.030	2.980 2.920	2.950	
14	Bracket Assembly	4.330Inches ± 0.030	4.360 4.300	4.330	
15	Bracket Assembly	5.510Inches ± 0.030	5.540 5.480	5.510	

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Container No: S190970



Part: D5062-041

Job No: 196177

Serial No/Batch: S190970

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K84 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/17/19

Entered: JKDate: Oct 25/19NCR No. 19-7568

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>196177</u> Part No. <u>D 5062 041</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐							
Date: <u>26/06/2019</u>		Sequence #: <u>170</u>		QTY Affected: <u>7</u>		MRB (QSI042) DAS 30 9-89 <u>SK</u>					
Description Work Order Deviation				Disposition							
<u>When riveting parts slide and was damage</u>				<u>Scrap + destroy</u> <u>No replace</u>							
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☒ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread							
								Other/Details:			